

Sup SAP- EAGLE!



PRELIMINARY ISSUE

Page 1

Work Order ID 71531

Wednesday, July 06, 2011 11:11:53 AM

Item ID: D4331-5

Revision ID: PRELIM

Item Name: Firewall

Start Date: 7/6/2011 Start Qty: 1.00

Required Date: 7/7/2011 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

QC:

Date:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Tooling:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D4331	Revision Nbr PA1								
100	FLOW WATER JET	0.00							
	Waterjet								
	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D4331								
304.022	Dwg Rev: PA1								
	Prog Rev: PA1								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
	QC								
	Memo	0.00							
Quality Control									

B11-7-6

B11-7-12 (2)

(1)

B11-7-6

B11-7-12

0.00 - inspected by PA1

See only

Smorloc (x)

Work Order ID 71531

Wednesday, July 06, 2011 11:11:53 AM



Item ID: D4331-5

Accept



Setup Start



Revision ID: PRELIM

Stop



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Start Date: 7/6/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Small Fab

SB 11/07/07

①

Small Fab

Memo

0.00

SB 11/07/11

①

Small Fab

FORM AS PER DWG

use only
1 (2 were cut)
for bend test

150

0.00



QC5- Inspect part completeness to step on W/O

- inspected to PA1

QC

Memo

0.00

Day only

8/10/07

⊗

Quality Control

180

0.00



Identify as per dwg & Stock Location: w/o

7/5/27

0.00

Packaging

Memo

11/07/13

Packaging

POSITIVE RECALL

EFFECTIVE

11/07/06

AUTH

11

RELEASED

DATE

Work Order ID 71531

Wednesday, July 06, 2011 11:11:53 AM



Item ID: D4331-5

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Firewall

Start Date: 7/6/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Picklist Print

Wednesday, July 06, 2011 11:11:50 AM

Page 1

Work Order ID: 71531

Parent Item: D4331-5

Parent Item Name: Firewall




Start Date: 7/6/2011

Required Date: 7/7/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 11-07-05 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA  304/316 .032 Sheet		Purchased	No				sf	45.8600		1.326316			



3.
B11-7-6
B11-7-12

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
020	5.8	
109057	5.8	
MAT020	40.06	
117379	40.06	

117379

①

DART AEROSPACE LTD		Work Order:	71531
Description: Pic way		Part Number:	4331-5 Bent
Inspection Dwg: D4331	Rev: Pa1		Page 1 of 1

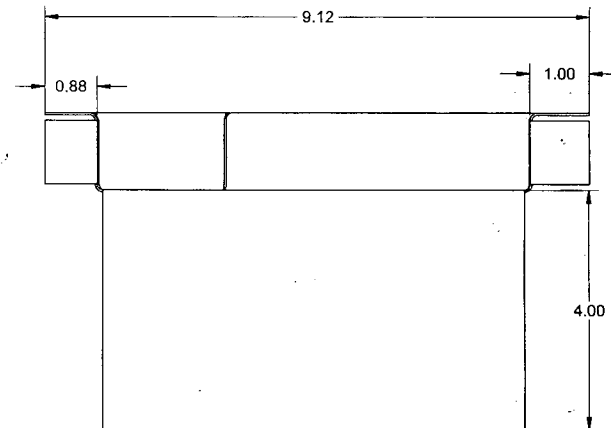
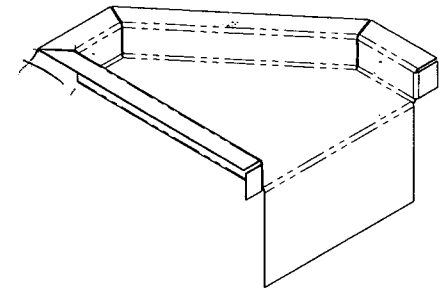
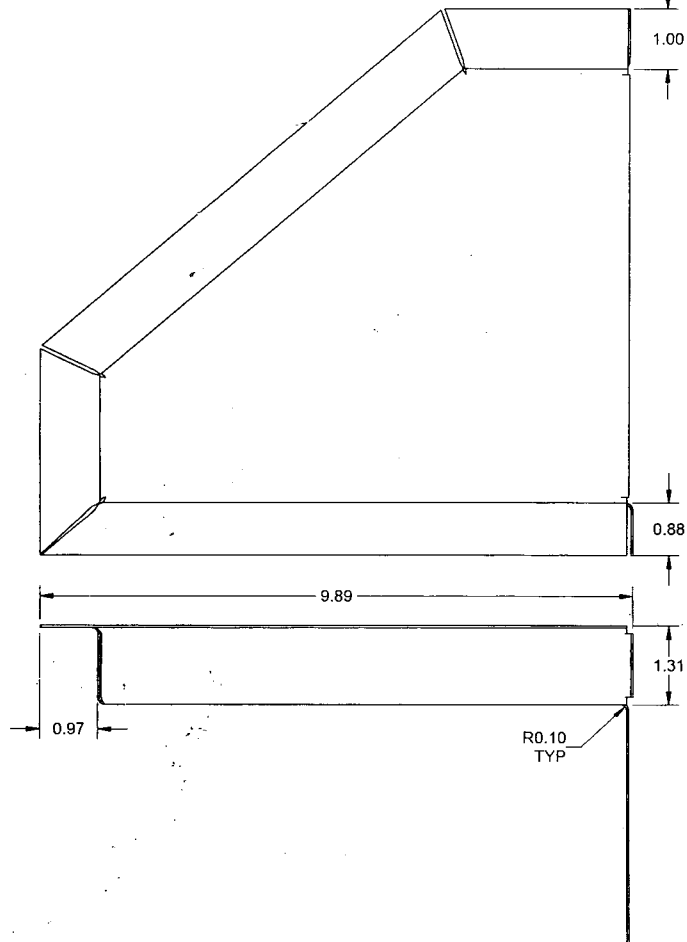
☒ **First Article** ☐ **Prototype**

[illegible]

Measured by: <u>SB</u>	Audited by: <u>[Signature]</u>	Prototype Approval: <u>N/A</u>
Date: <u>11/07/07</u>	Date: <u>11/02/07</u>	Date: <u>N/A</u>

to R21 Day only

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



- NOTES:
- 1) MATERIAL: MADE FROM D4331-5F
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.16 lbs

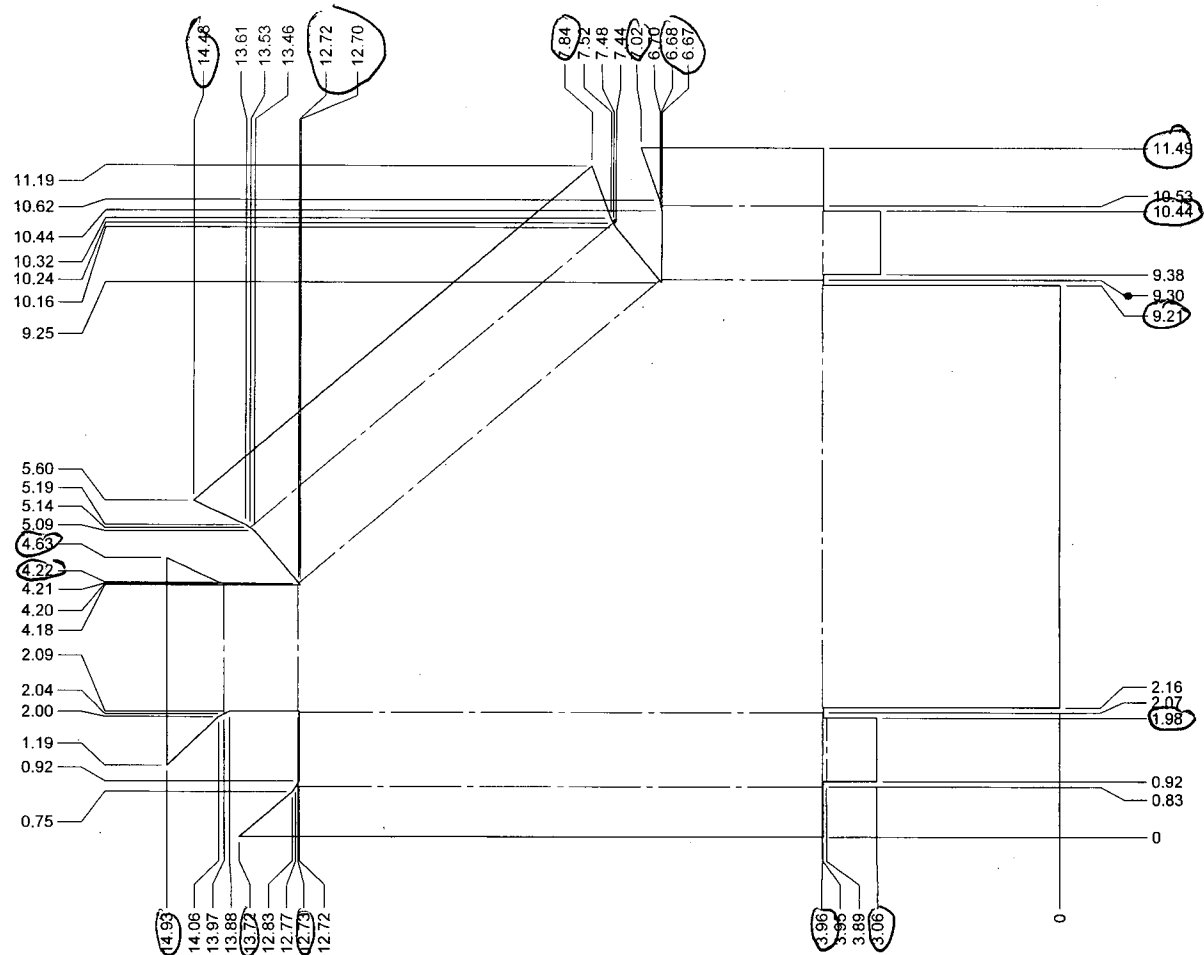
WLO 7531

D4331-5 FIREWALL

PRELIMINARY ISSUE

11.02.03

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D4331	SHEET 7 OF 8
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
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D4331-5F

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 22 GAUGE
PER MIL-S-5059
OR AMS 5513 OR AMS 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S22GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.16 lbs

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